

**Work Order ID 72169**

Tuesday, July 19, 2011 1:52:17 PM



Page 1

Item ID: D3508-3

Accept



Setup

Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 7/19/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: *H*Date: *14-07-19*

Tooling:

Date:

Run

Start



QC:

Date: *14-07-19*

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3508	Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

*B11-8-9*

FLOW CNC Waterjet

*304.40*

I-Cut as per Dwg D3508

 Dwg Rev: *C*  Prog Rev: *C*  2-

Deburr if necessary

*(D)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



Memo

0.00

*B11-8-9*

Quality Control

120

QC8- Inspect parts - second check

0.00



Memo

0.00

*S110810**(fcl)*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 72169**

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Page 2

Item ID: D3508-3

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Setup

Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 7/19/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



NC BRAKE

0.00

(12)

BB 11-08-12

Brake NC

Memo

0.00

Brake NC

1-Form on brake using DT8326 and DT8261as per Dwg D3508 2-Form joggle  
as per Dwg D3508 Using DT8158

140



QC5- Inspect part completeness to step on W/O

0.00

5 Aug 12

QC

Memo

0.00

Quality Control

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

12x 4 m. 11/08/15

Powdercoat

Powder Coating

Memo

7'45 0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

320° F 8:15

W112338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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**Work Order ID 72169**

Tuesday, July 19, 2011 1:52:17 PM



Page 3

Item ID: D3508-3

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 7/19/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 8.00



Customer:

**Reference:**

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**Sequence ID/  
Work Center ID****Operation  
Description**

160



QC

Quality Control

QC3- Inspect Part Finish

**Set Up/  
Run Hours**

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

12 d M 168/15

170



Packaging

Packaging

Identify as per dwg & Stock Location: F-P

0.00

QD m/h/168/15

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/18/15 ff.

MF 11-08-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

Tuesday, July 19, 2011 1:52:23 PM

Page 1

Work Order ID: 72169



Parent Item: D3508-3



Parent Item Name: Wearplate

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-06-20 JLM  
IPP Rev:B Now SS as per Rev B 06-12-15 JLM  
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased		No		100	sf	110.0630	0.734	6.181053	9,		 B1-9-8

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	110.063	
116623	0.2	
117550	9.363	
117933	100.5	

118400

118400

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	72169
Description: Wearplate	Part Number:	D3508-3
Inspection Dwg: D3508	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11-8-9	Date:	11/08/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	 

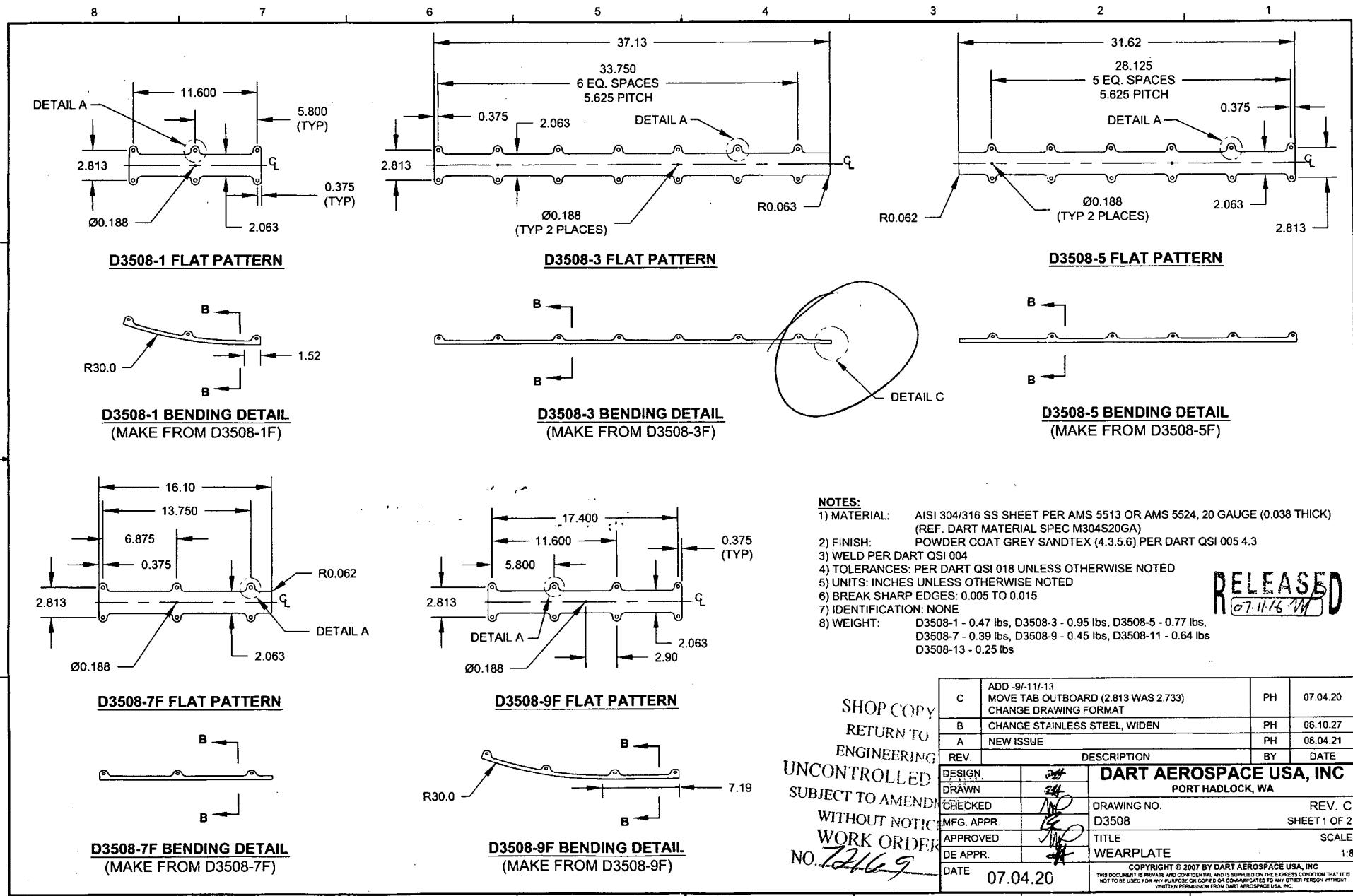
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



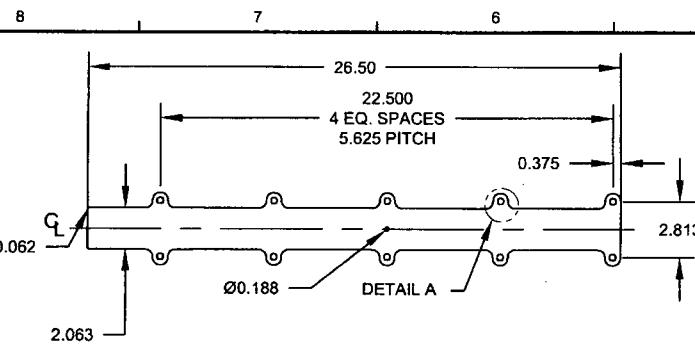
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

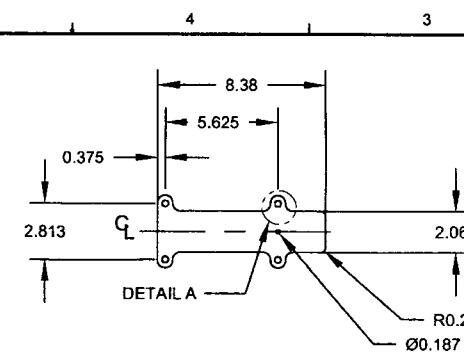
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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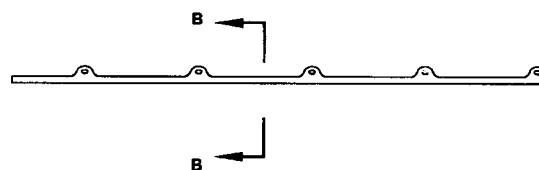
NOTE: Date & initial all entries



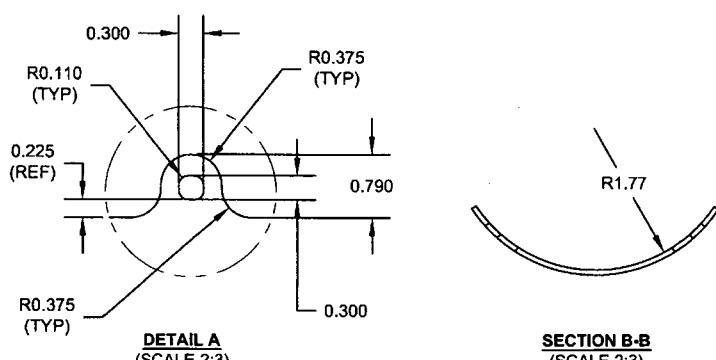
D3508-11F FLAT PATTERN



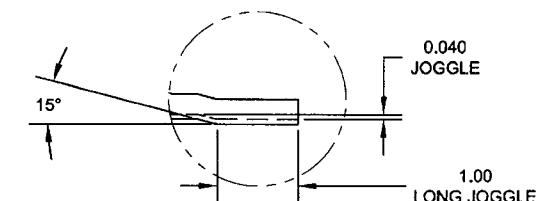
D3508-13F FLAT PATTERN



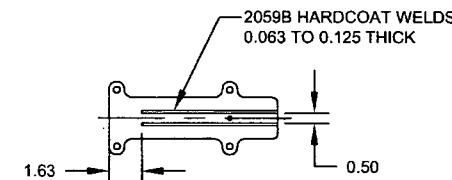
D3508-11 BENDING DETAIL  
(MAKE FROM D3508-11F)



D3508-13 BENDING DETAIL  
(MAKE FROM D3508-13F)



DETAIL C  
(SCALE 1:2)



D3508-13 WELDING DETAIL

72169  
RELEASED  
07-11-14

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3508	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:6
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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